

Date: Tuesday, 7/1/2008 2:35:12 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR
Job Number : 40201	
Estimate Number : 10766	
P.O. Number :	Part Number : D32453
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D3245 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35693	Material :
Written By : <u>[Signature]</u>	Due Date : 7/11/2008 Qty: 6 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est. A 04.07.07 New issue KJ/JLM	
Est Rev:B Now on Waterjet 07-09-14 JLM Verified By:EC	
Est Rev:c ECN 1052 07-10-31 DD verified by:	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S22GA 304/316 .032 Sheet



S. MAT NOT pulled from

Comment: Qty.: 0.5639 sf(s)/Unit Total : 3.3831 sf(s)

304/316 .032 Sheet

BATCH: 10903 1B 8-8-05

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary, buff entire surface to ensure a nice surface finish.

Form D3245-3 as per Dwg D3245

Identify as D3245-3

8/08/09/02 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3245-3 PAR #: N/A Fault Category: Prod / FMS. PSS. med & small NCR: Yes No DQA: D Date: 08/09/05  
D3245-043 Water Jet. QA: N/C Closed: D Date: 08/09/05  
D412-705-013

NCR: <u>40201</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/6	# 20	All 6 parts made with 0.022 thick mat. Suspected to be .032" thick. Mat. used has 22# G. but measure .032" thick. P.C. wrong Dim written on sheet.	<u>08.08.06</u>	Scrap and Destroy AND Replace Qty <u>(x6)</u>	<u>8-8-05</u>	<u>08/08/05</u>	<u>08.08.06</u>	<u>8/8/6</u>
<u>08.09.02</u>	#5.0	8.00" IS 8.04" ON QTY. 1 D3245-3.	<u>08.09.02</u>	ACCEPTABLE DEVIATION THIS BATCH ONLY. QTY. 1.	<u>08/09/02</u>	<u>08/09/03</u>	<u>08.09.02.</u>	<u>08/09/03</u>

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:35:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 40201

Part Number: D32453

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 08/09/03 (X7)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SO 08/09/03 (7)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 HJ

Job Completion



MF 08-09-03

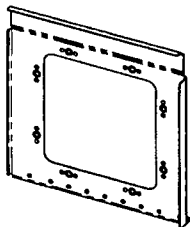
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

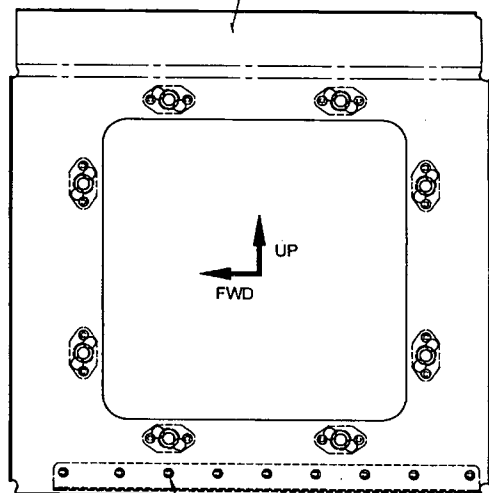
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



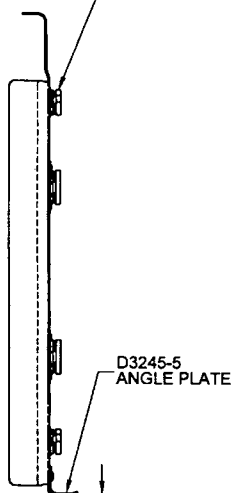
D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

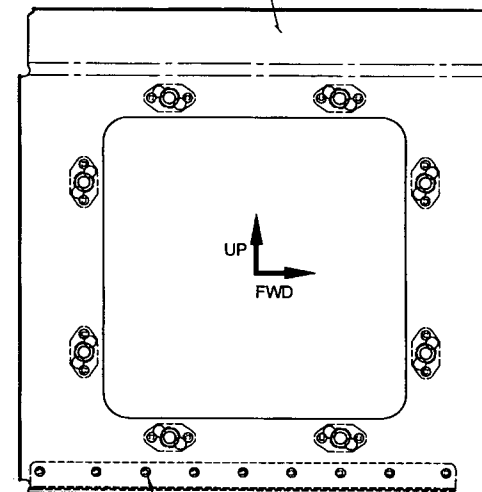
**D3245-041 ACCESS PANEL ASSEMBLY**



0.032  
GAP

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

**RELEASED**  
07-10-23

**NOTES:**

1) MATERIAL: N/A

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) DIMS: INCHES UNLESS OTHERWISE NOTED

5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER

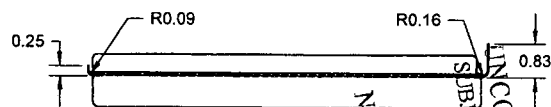
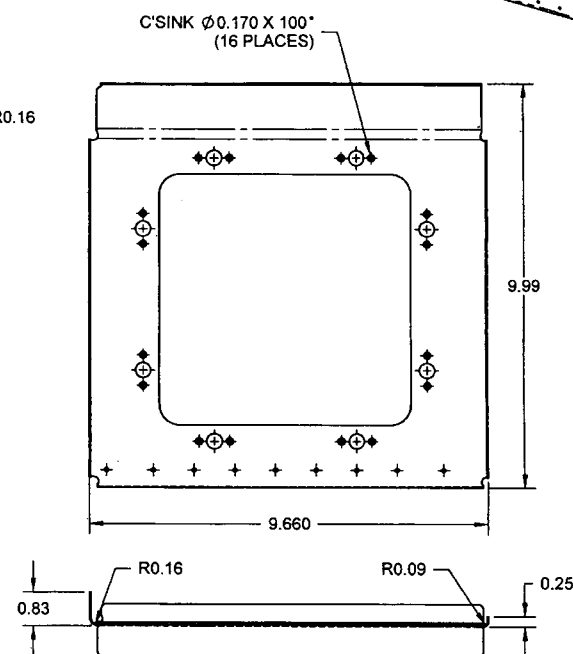
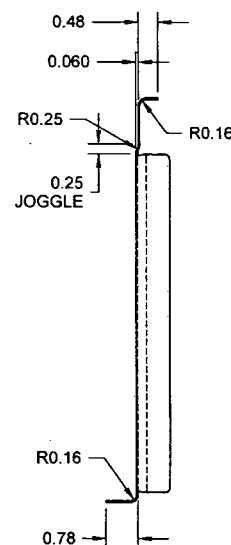
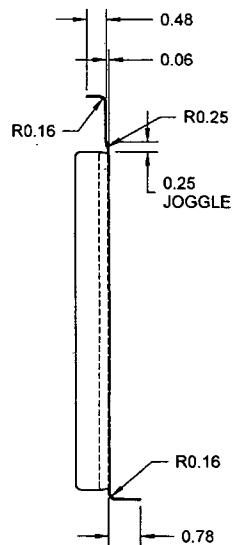
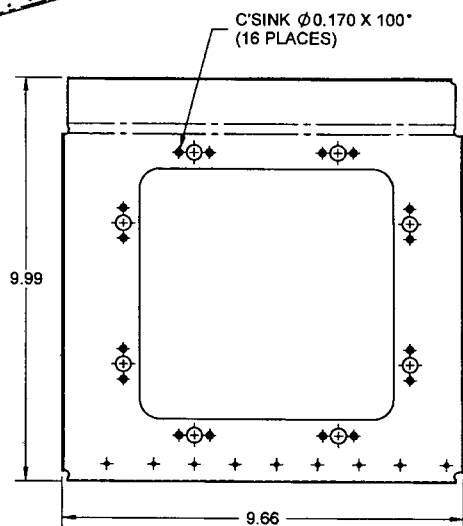
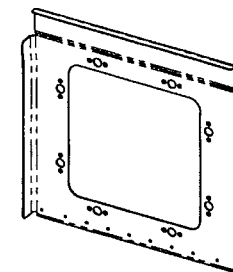
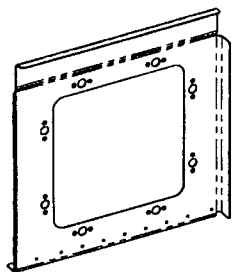
7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JH	DRAWING NO.	REV. B
CHECKED	JH	<b>D3245</b>	SHEET 1 OF 7
MFG. APPR.	JH	TITLE	SCALE
APPROVED	JH	<b>ACCESS PANEL ASSEMBLY</b>	1:2.5
DE APPR.	JH	DATE <b>07.10.02</b>	
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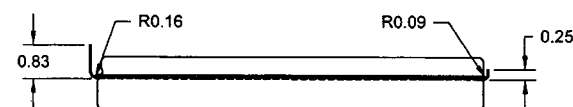
NO. 42201  
WORK ORDER

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COPY



**D3245-1 PANEL BEND DETAIL, LH**



**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
07-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3245</b>	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>ACCESS PANEL ASSEMBLY</b>	1:3
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D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)D3245-7 GASKET  
(REF)8.00  
(TYP, REF)**D3245-043 DOOR ASSEMBLY**INSTALL D3245-7  
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

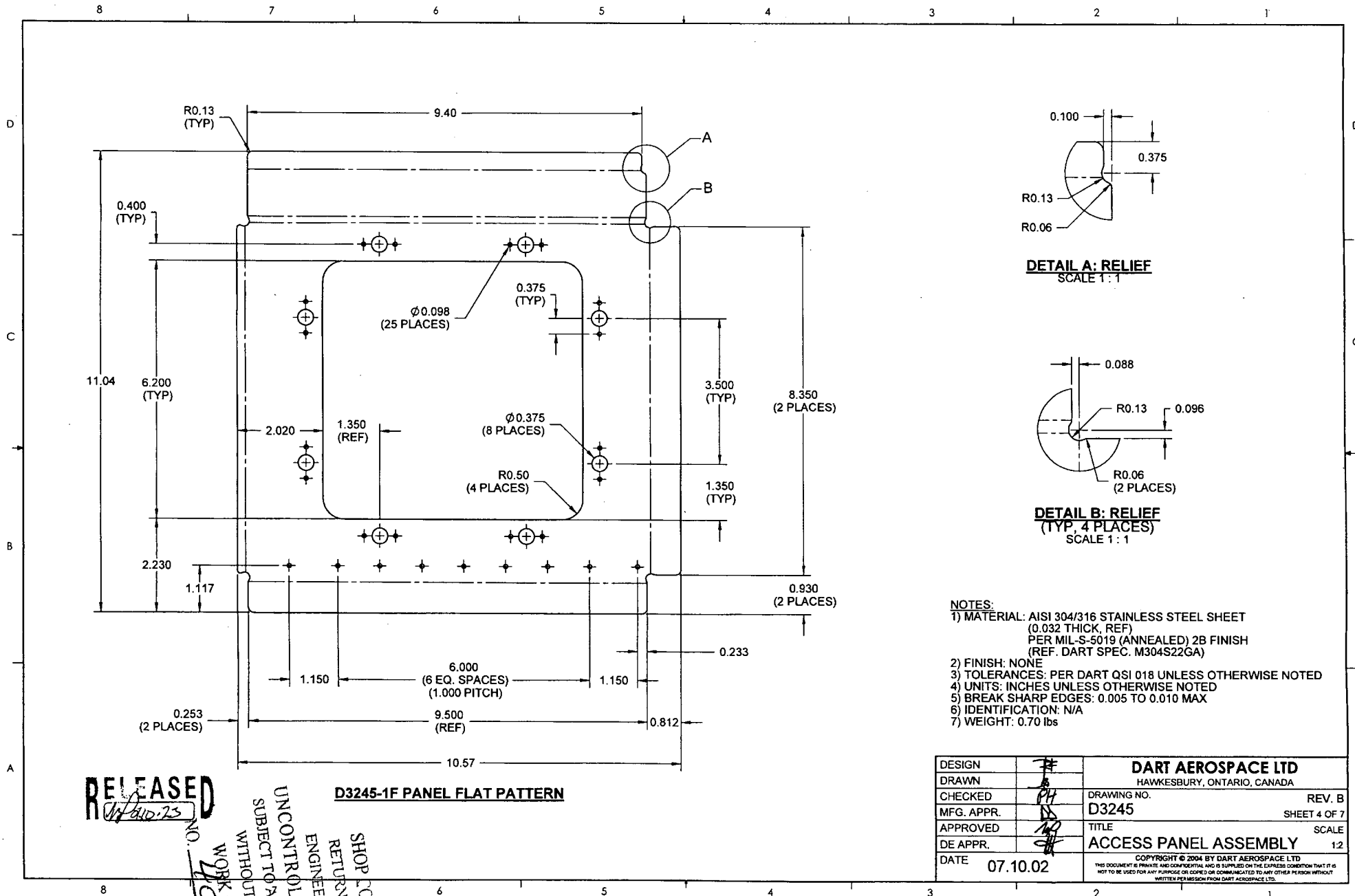
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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MFG. APPR.	<del>PH</del>	REV. B
APPROVED	<del>PH</del>	SHEET 3 OF 7
DE APPR.	<del>PH</del>	TITLE <b>ACCESS PANEL ASSEMBLY</b>
DATE	07.10.02	SCALE 1:2
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(7/27/03)

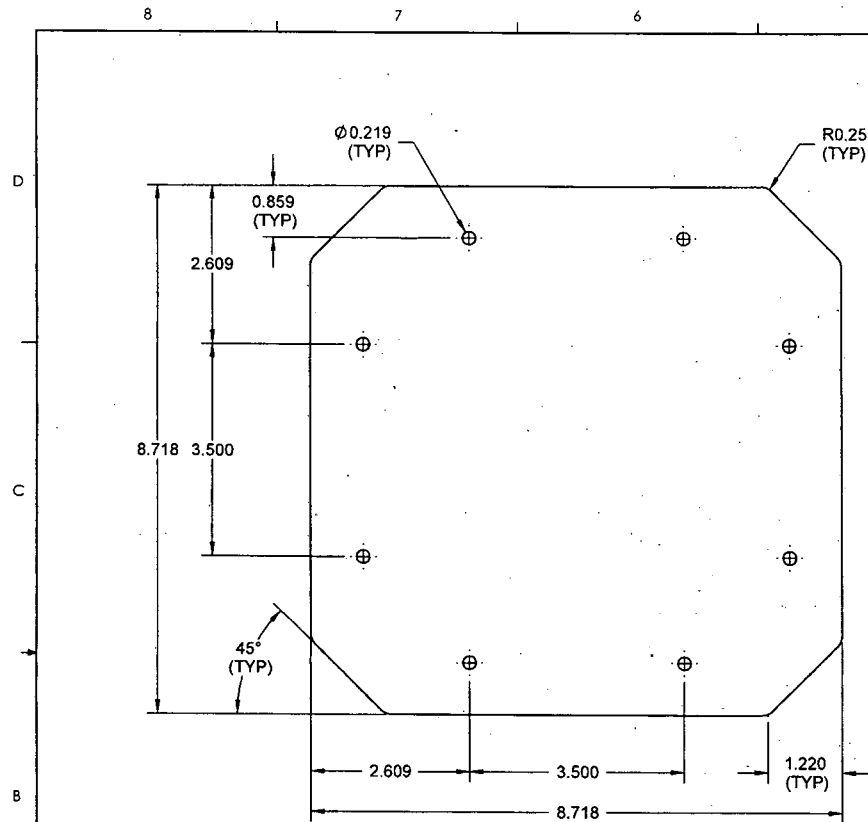
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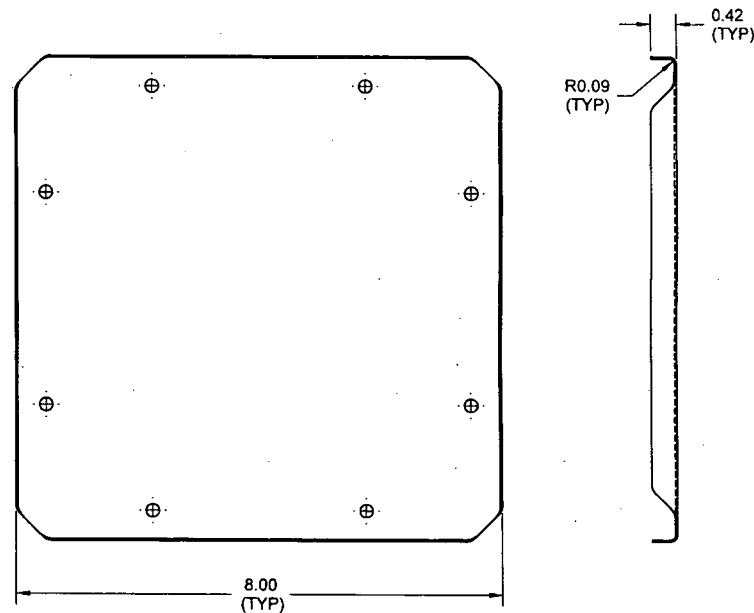
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17/010.23

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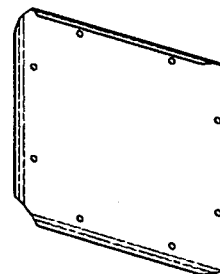




**D3245-3F DOOR FLAT PATTERN**



**D3245-3 DOOR BENDING DETAIL**



**NOTES:**

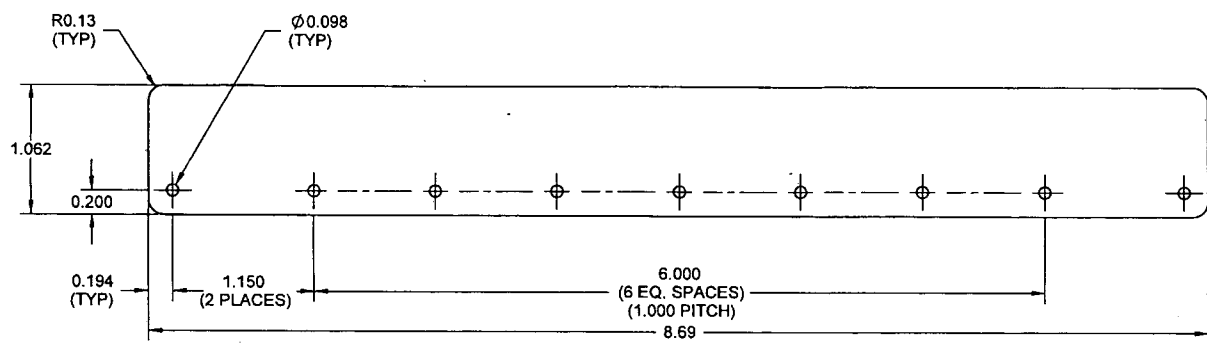
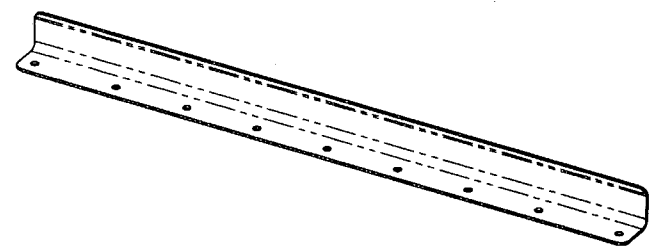
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	7F	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	D3245	SHEET 5 OF 7
MFG. APPR.	PH	TITLE	SCALE
APPROVED	PH	ACCESS PANEL ASSEMBLY	1:2
DE APPR.	PH	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

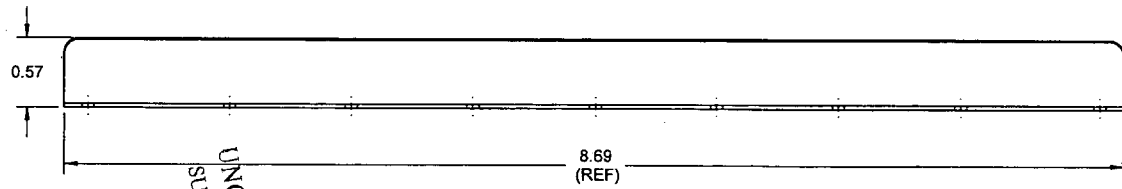
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07-10-03

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WORK ORDER  
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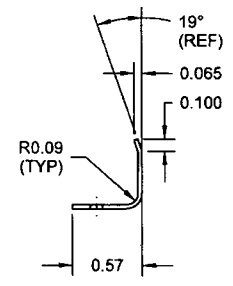
8 7 6 5 4 3 2 1



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL  
(MAKE FROM D3245-5F)**



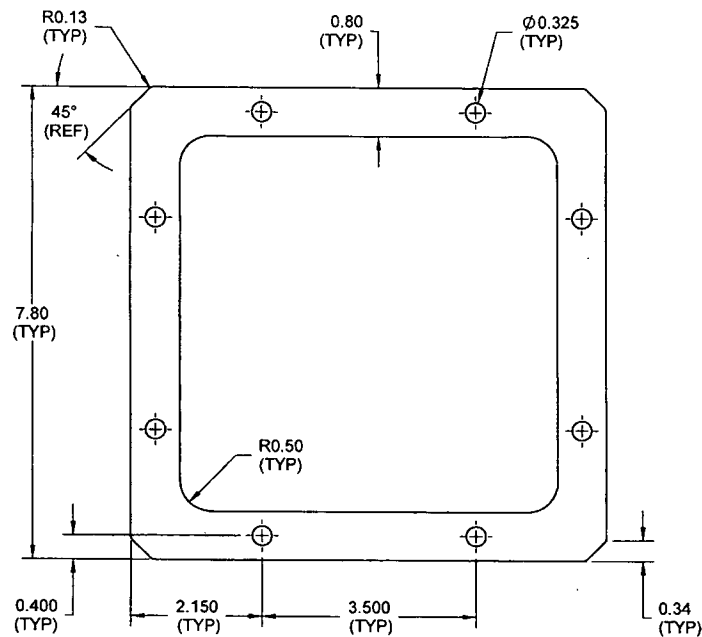
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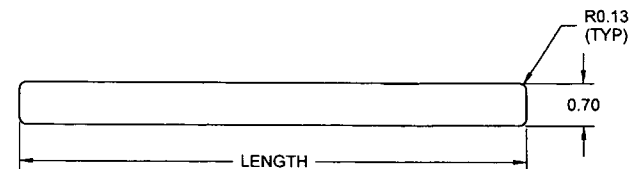
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN	<del>PH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>PH</del>	D3245	SHEET 6 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	ACCESS PANEL ASSEMBLY	1:1
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8 7 6 5 4 3 2 1



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**RELEASED**  
07.10.02

NO. 103-01  
WORK ORDER  
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**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<del>TH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<del>DS</del>		SHEET 7 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	<b>ACCESS PANEL ASSEMBLY</b>	1:2
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